



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400221-109
Job Sheet 178356



Part No: RBT400221-109

Job Qty: 12 ea

Part Name: Turnbuckle



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/30/18

Job Tracking No:

Due Date: 7/18/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT400221 REV 3A IPP REV A 18.05.29 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Machining-4	9.00	JB 18.07.25
120	CNC Lathe	12 pcs	7/18/18	7/18/18	0.00	1.20	MORI SL-154	1.00	JB 18.07.25
130	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC2 Machining-5	1.00	JB 18.07.25
140	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC8 Machining-5	1.00	JB 18.07.25
150	Outsource	12 pcs	7/18/18	7/18/18	0.00	0.00	Outsource12	1.00	CC 18.7.27
160	Packaging	12 pcs	7/18/18	7/18/18	0.00	0.00	Packaging2	1.00	AUG 01 2018
170	QC	12 pcs	7/18/18	7/18/18	0.00	0.00	QC6	1.00	DA 18.08.03
180	Packaging	12 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-2	1.00	DA 18.11
190	QC21-SA	12 Ea	7/18/18	7/18/18	0.00	0.00	QC21	1.00	21 AUG 14 2018

Part Op 120 - 1-Machine as per folio FC 246 FOLIO REV: 040623

DWG REV: 9-88

Descriptions: 150 - Issue P/O to GROUPE ALTECH; PO 040623 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type Stress Proof; -Certificate of Conformity is required

160 - Receive

180 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.750	Steel Proof Round Bar 0.750"	1.7280 ft (.144 ea)	90-Start up Operation	5093067
MT-4140QT-R0.750	FL			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1144-R0.750	2	16	0

Part Specifications

Specifications could not be found.

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Container No: S096433



Part: RBT400221-109

Job No: 178356

Serial No/Batch: S096433

Revision: 3A

Inspector:

Exp Date:

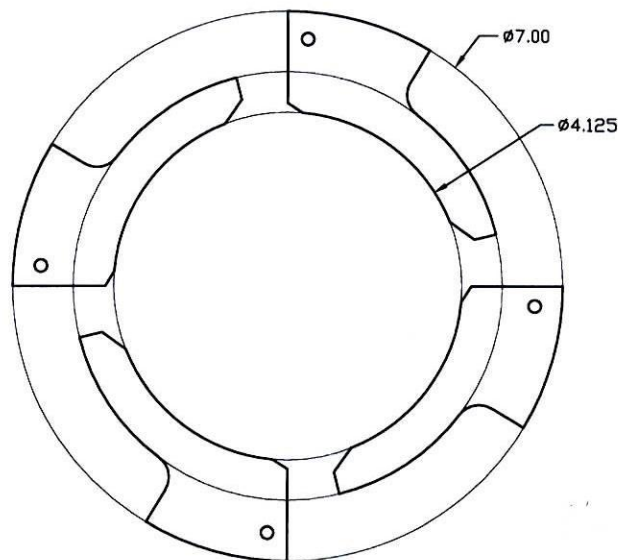
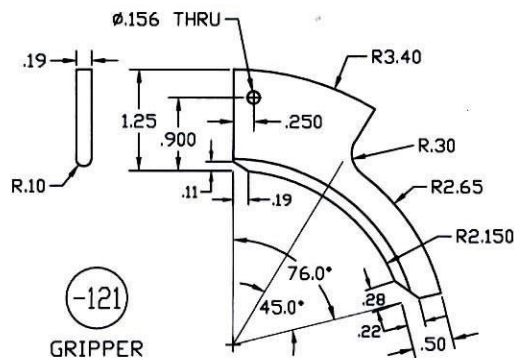
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

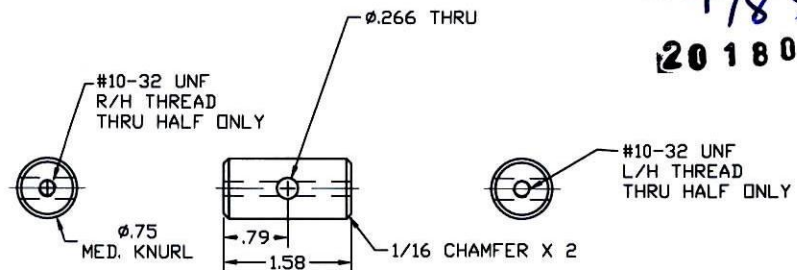
Date: 07/25/18

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CH'D BOM P/N -121 MATERIAL FROM STEEL & FROM PLATE TO ROUND, PER D.W., ADDED NOTE SHEET 3 of 3.	11/3/09	RJC
2	REMOVED GROOVE FROM P/N-109, ADDED NOTE P/N-120A & -120B ASSEMBLY PER R.W.	11/25/09	RJC



NOTES:
BUY 7" ROUND 4140 Q&T WATER JET I.D. @ Ø4.125 & O.D. @ Ø7.00. MACHINE FROM DOUNUT AS SHOWN.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178356

20180718

RED BARN MACHINE	
TITLE TOOL - DRIVESHAFT REMOVAL	
DWG NO. RBT400221-109 & -121	REV 3A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ± .5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 5-20-02
SHEET 3 of 3	

MTH
4140/4143
(28-32 Rc)
JULY 19/18



Certificat de Conformité / Certificate of Compliance

(011405-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011405 - 2

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
01-Aug-2018		Aman		040622				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
4	RBT400221-109 Rev.	RBT400221-109 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL	OXIDE-BLACK CH	12	12	0	0	0
7	RBW6205G19332-3G-1 Rev.	RBW6205G19332-3G-1 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, TYPE 2 SC2 ASTM B633 TYPE 2 SC2	ZINC CH	7	7	0	0	0
8	SK145-0115-20 Rev.	SK145-0115-20 01-PASSIVATION- #3 [PASSIVATION #3] SPÉC: ASTM A967 C OF C *** SPÉC: AS PER DRAWING ***	PASSIVATION CH	20	20	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040622**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040622
PO Date: 7/27/18
Due Date: 7/31/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174443	RBW6305G01232-3G-1	Receiver -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	-	7/31/18	12 pcs	0 pcs	12 pcs	\$14.5833333/pcs	\$175.00
2	178201	RBEM262V3000101-21	Plate -Issue P/O to GROUPE ALTECH: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	7/31/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
3	179860	SWA3-300	Wire Clamp -Issue P/O to Groupe Altech: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	7/31/18	19 pcs	0 pcs	19 pcs	\$6.31578947/pcs	\$120.00

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	178356	RBT400221-109	Turnbuckle -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type Stress Proof; -Certificate of Conformity is required	Firmed	-	7/31/18	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
5	181471	C10-6	Trunnion 1-Issue P/O to Groupe Altech; P/O _____ RC 44-46 2-Nickel plate - 0.0009-0.0011, Bake after plating 3- Certificate of Conformity is required	Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$240.00/pcs	\$240.00
6	179961	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required	Firmed	-	7/31/18	2 pcs	0 pcs	2 pcs	\$60.00/pcs	\$120.00
7	180205	RBW6205G19332-3G-1	Draw Bolt -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	-	7/31/18	7 pcs	0 pcs	7 pcs	\$12.8571429/pcs	\$90.00
8	177589	SK145-0115-20	Clamp Bar ISSUE P/O: _____ PASSIVATE AS PER DWG ACCORDANCE WITH ASTM A967 C OF C IS REQUIRED	Firmed	-	7/31/18	20 pcs	0 pcs	20 pcs	\$5.00/pcs	\$100.00
Grand Total:											\$1,085.00

Order Notes

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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